

Work Order ID 59376

Wednesday, June 02, 2010 1:32:20 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 6/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *H* Date: 10-6-02 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100 Large Fab 0.00



Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 111679

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

 PL 10.06.23

 QD 10.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59376

Wednesday, June 02, 2010 1:32:20 PM

Page 2

Item ID: D2221

Accept

Revision ID:

Item Name: 350 Basket Base

Start Date: 6/2/2010 Start Qty: 1.00

Required Date: 6/9/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

1- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

N/A

small

f

① BL 10-6-24.

① BL 10-6-24.

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ES 10/06/25 @

150



Packaging

Packaging

Identify as per dwg & Stock Location: *GA**W/p 59375*

0.00

Memo

0.00

ES 10/06/25 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

ES 10/06/25 @

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Picklist Print

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Work Order ID: 59376

Parent Item: D2221

Parent Item Name: 350 Basket Base

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1

Manufactured No

100

Each

15.0000

1

1



Rib

Location

Loc Qty

Loc Code

WA

15

57182

1

57499

2

58122

12

✓ D2221-5

Manufactured No

100

Each

12.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

12

57500

4

58027

8

✓ D2221-7

Manufactured No

100

Each

6.0000

1

1



Rib

Location

Loc Qty

Loc Code

WA

6

57501

2

57805

4

✓ D2232-3

Manufactured No

100

Each

14.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

14

57502

4

57793

6

59264

4

Pl 10.06.17

Pl 10.06.17

Pl 10.06.17

Pl 10.06.17

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Page 2 14

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D2235-1 Manufactured No 100 Each 18.0000 2 2
 Basket Rib
PL 10.06.17
B59267 → (2)

Location	Loc Qty	Loc Code
WA	18	
57593	2	
57792	6	
59035	10	

✓ D2581 Manufactured No 100 Each 73.0000 2 2
 Mounting Bracket
PL 10.06.17
B59121 → (2)

Location	Loc Qty	Loc Code
ST	22	
59121	22	
WA	73	
46086	2	
51745	2	
57185	1	
58301	5	
58687	20	
59265	21	

✓ D3442-1 Manufactured No 100 Each 24.0000 2 2
 Shim
PL 10.06.17

Location	Loc Qty	Loc Code
WA	24	
56579	12	
58028	12	

W/O:		WORK ORDER CHANGES					
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041	Manufactured	No	100	Each	4.0000	2	2	
Rib Assembly (Basket End)								
	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
	WA			4				
	58025			4				
✓ D3826-041	Manufactured	No	100	Each	4.0000	2	2	
Rib / Gusset Assembly								
	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
	WA			4				
	57835			4				
✓ D3827-041	Manufactured	No	100	Each	6.0000	1	1	
Rib Assembly (Inboard)								
	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
	WA			6				
	57802			6				
✓ D3832-1	Manufactured	No	100	Each	4.0000	1	1	
Mesh (Base)								
	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
	WA			4				
	57791			1				
	58165			3				

Pl 10.06.17
 B58998 → ②
 Pl 10.06.17
 B58981 → ②
 Pl 10.06.17
 B55276 → ①
 Pl 10.06.22
 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4 *14*

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-1

Manufactured No

100

Each

13.0000

2

2



Mesh (Base End Face)



Pl 10.06.23

Location

Loc Qty

Loc Code

WA

13

56396

1

57834

4

59184

8

2

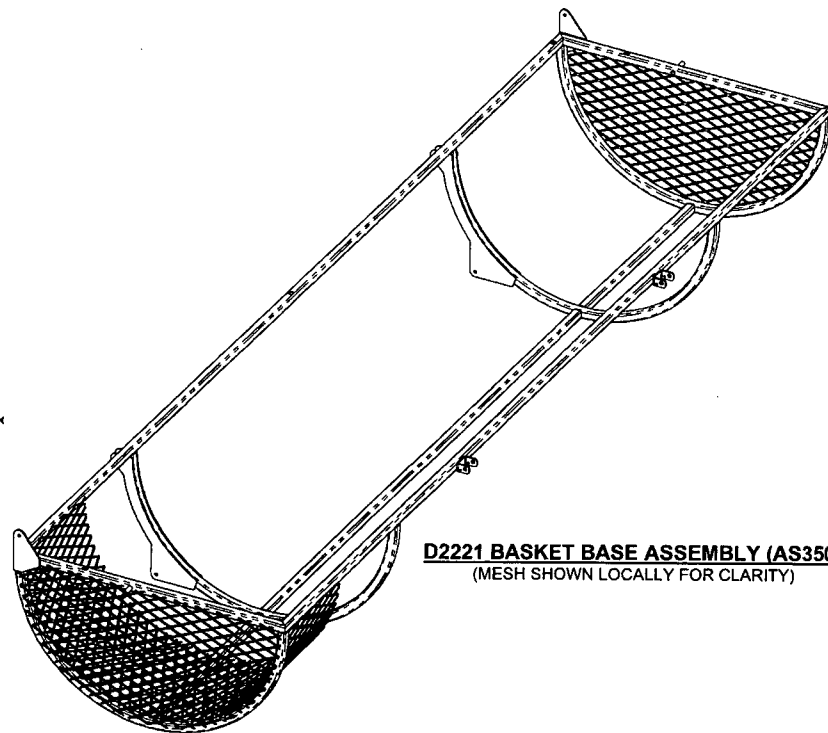
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59374

BS10-6-02

RELEASED
05/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.82 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.05.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

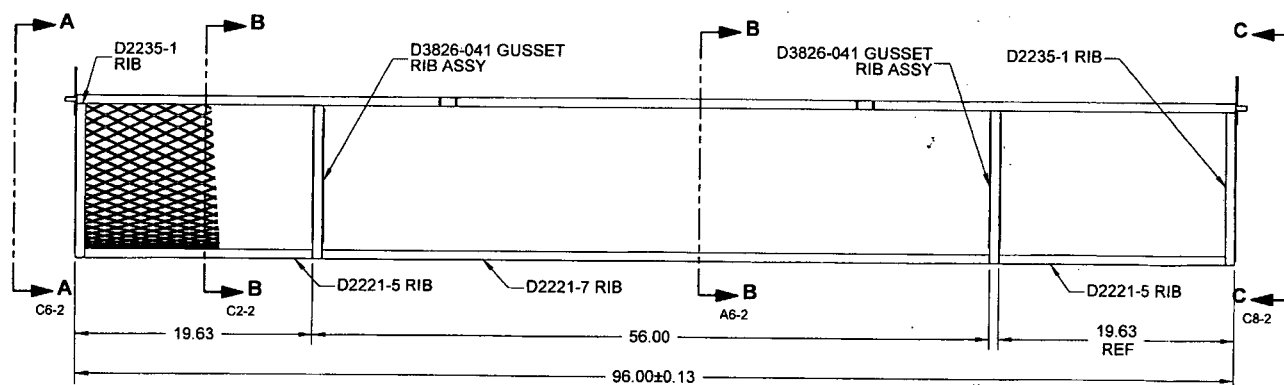
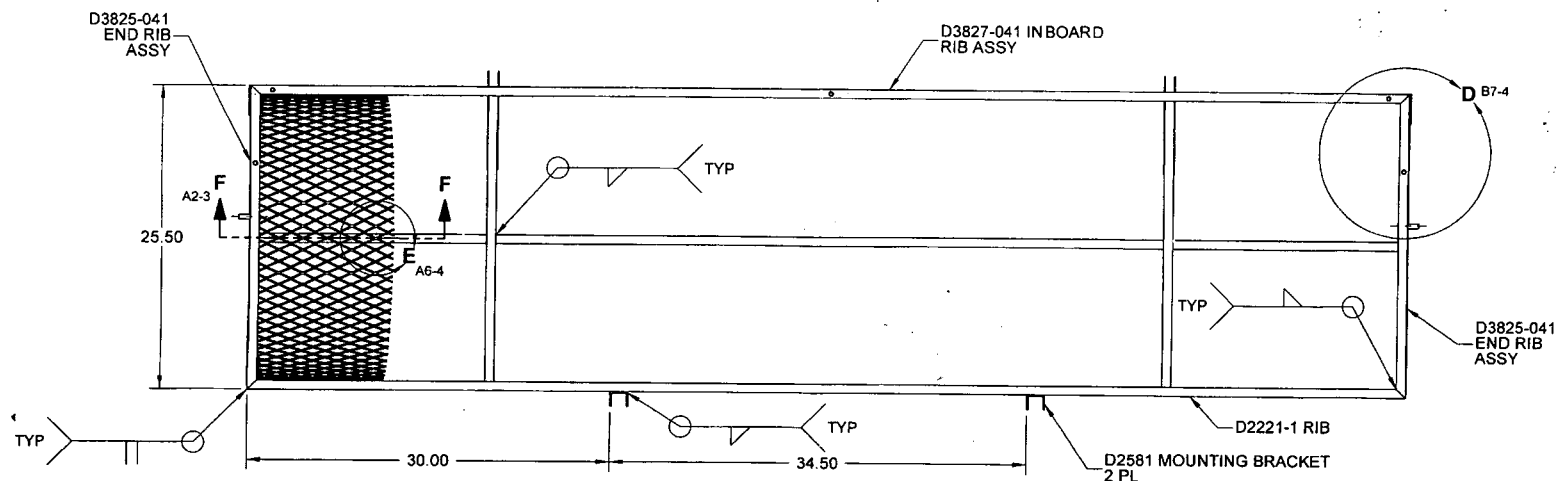
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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W10 59376

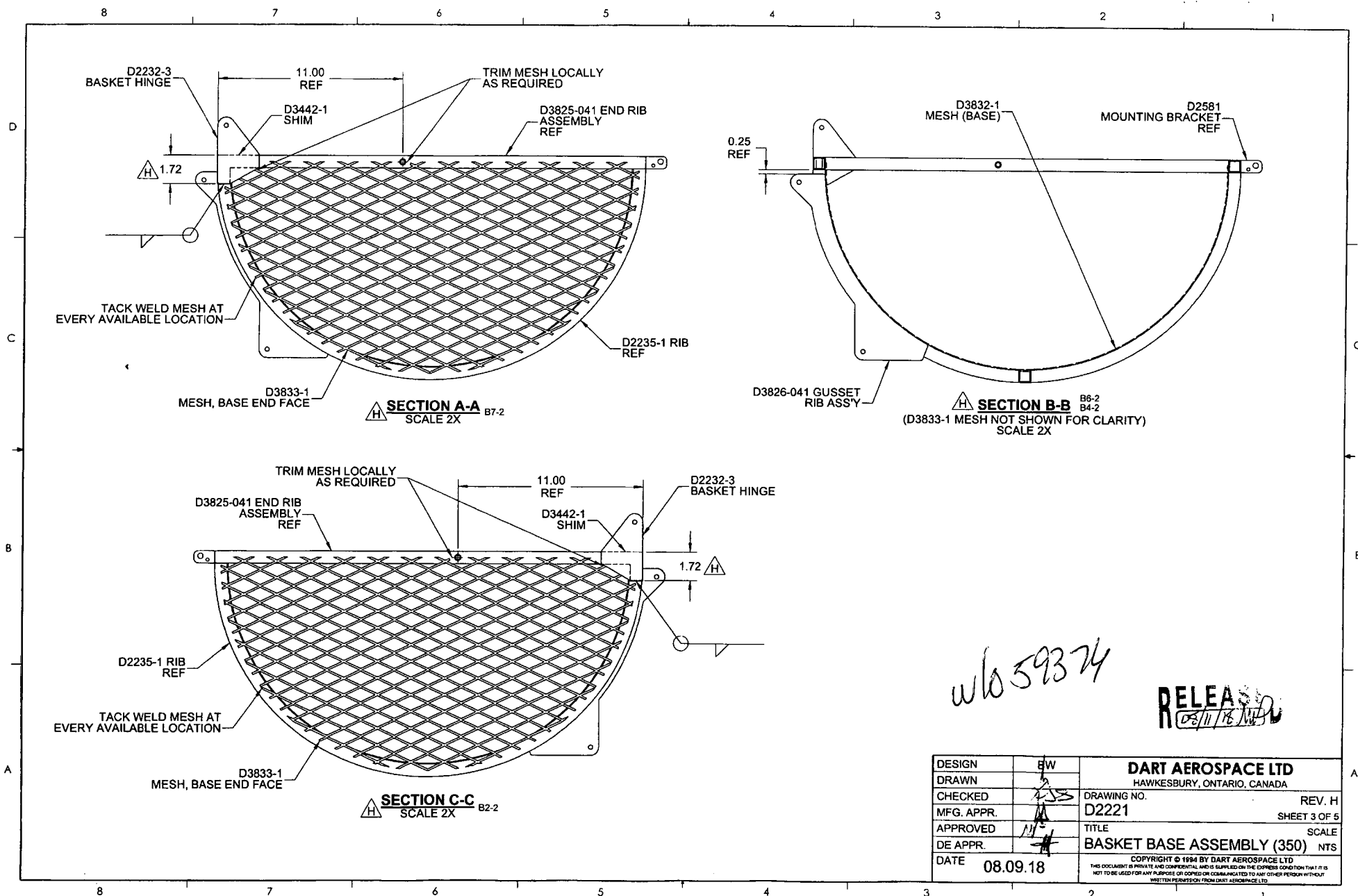
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



wlb 59374

RELEASED
03/11/16

DESIGN	HW	DART AEROSPACE LTD	
DRAWN	255	HAWKESBURY, ONTARIO, CANADA	
CHECKED	11	DRAWING NO.	REV. H
MFG. APPR.	11	D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	BASKET BASE ASSEMBLY (350)	NTS
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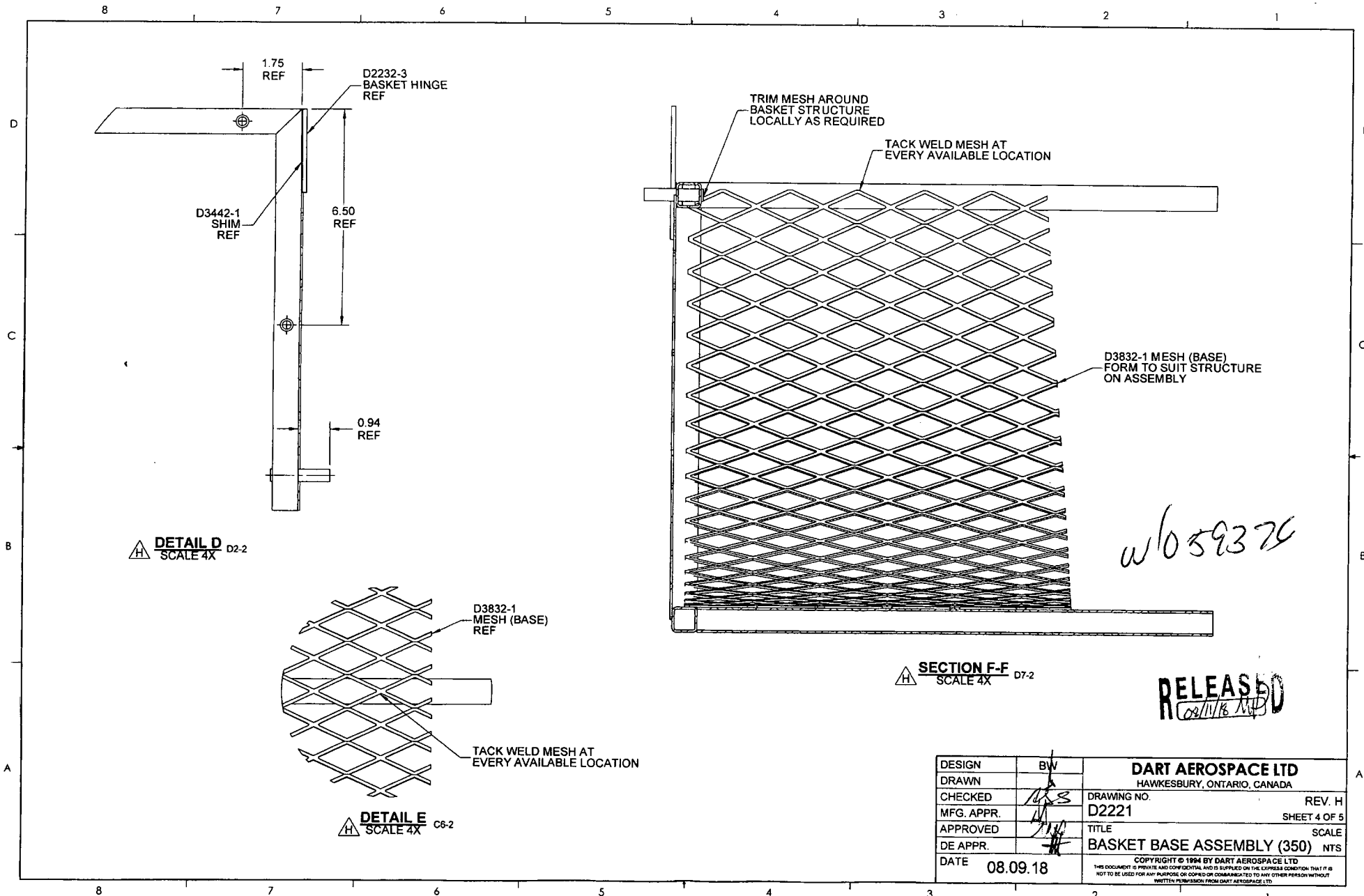
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DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D2221	REV. H SHEET 4 OF 5
MFG. APPR.		TITLE BASKET BASE ASSEMBLY (350) NTS	SCALE
APPROVED		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.			
DATE	08.09.18		

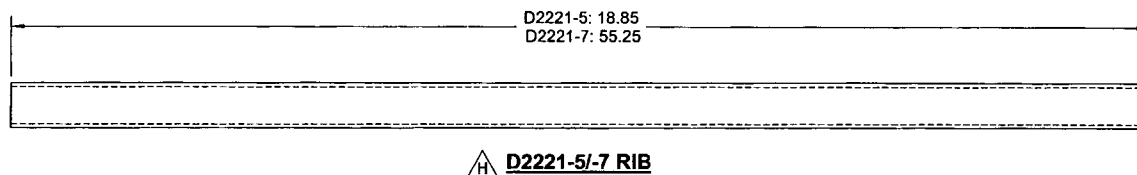
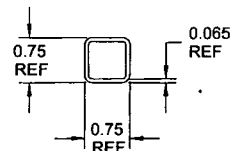
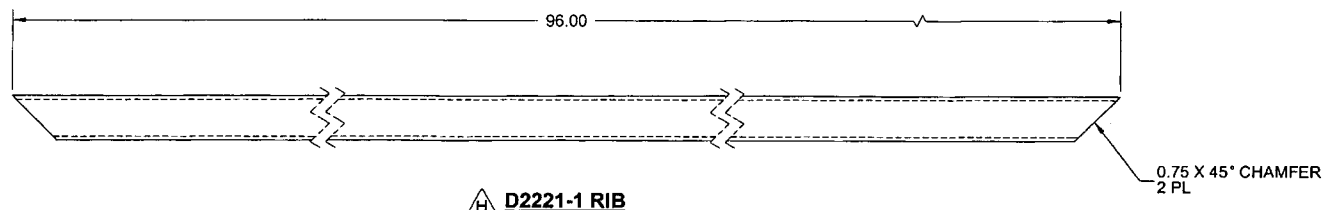
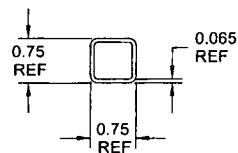
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NOTE: Date & initial all entries



w/b 59374

RELEASED
08/10/18

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries